

Date: Friday, 2/23/2007 8:32:22 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 30899	
Estimate Number : 10710	
P.O. Number : N/A	Part Number : D32111
This Issue : 2/23/2007 S.O. No. : N/A	Drawing Number : D3211 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A1
Previous Run : 29553	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 3/14/2007
Checked & Approved By : <u>[Signature]</u> 07.02.23	Qty: 10 Um: Each
Comment : Est Rev: A New Issue 05-11-17 JLM	
Est Rev: B Now on Waterjet 06-10-24 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 1.4753 sf(s)/Unit Total: 14.7525 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063) Identify as D3211-1

Batch: M102942 M103321 SAD 07/02/28

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3211

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

SAD 07/02/28 10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/02/28 10

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/02/28

(10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD 07/03/05

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:32:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 30899

Part Number: D32111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend D3211-1 Stack as per Dwg D3211

SB 07/03/14

(10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/14 (9)

(P10)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

07/03/15

(9X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/03/15

(X9)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-L

07/03/15

(9X)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/15 (9X)

PK

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/17

(9)

Job Completion



U 07.03.16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3211-1 PAR #: N/A Fault Category: Prod / FAB. ASS. med & small NCR: Yes No DQA: 2 Date: 07/03/19
 QA: N/C Closed: 1 Date: 07.03.19

NCR: <u>30899</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/07	2.0	Grain wrong Grain direction 6 parts	<u>Qs1042</u>	<u>Scrap & destroy Replac.</u>	<u>SAN</u> <u>07/02/27</u>	<u>07-02-27</u>	<u>Qs1042</u>	<u>07-02-27</u>
07/03/14	6.0	Part cracked from bending.	<u>Qs1042</u>	<u>Scrap & destroy</u>	<u>8B</u> <u>07/03/14</u>	<u>07-03-14</u>	<u>Qs1042</u>	<u>07-03-14</u>

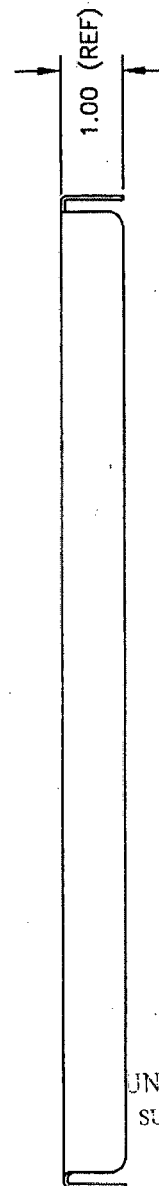
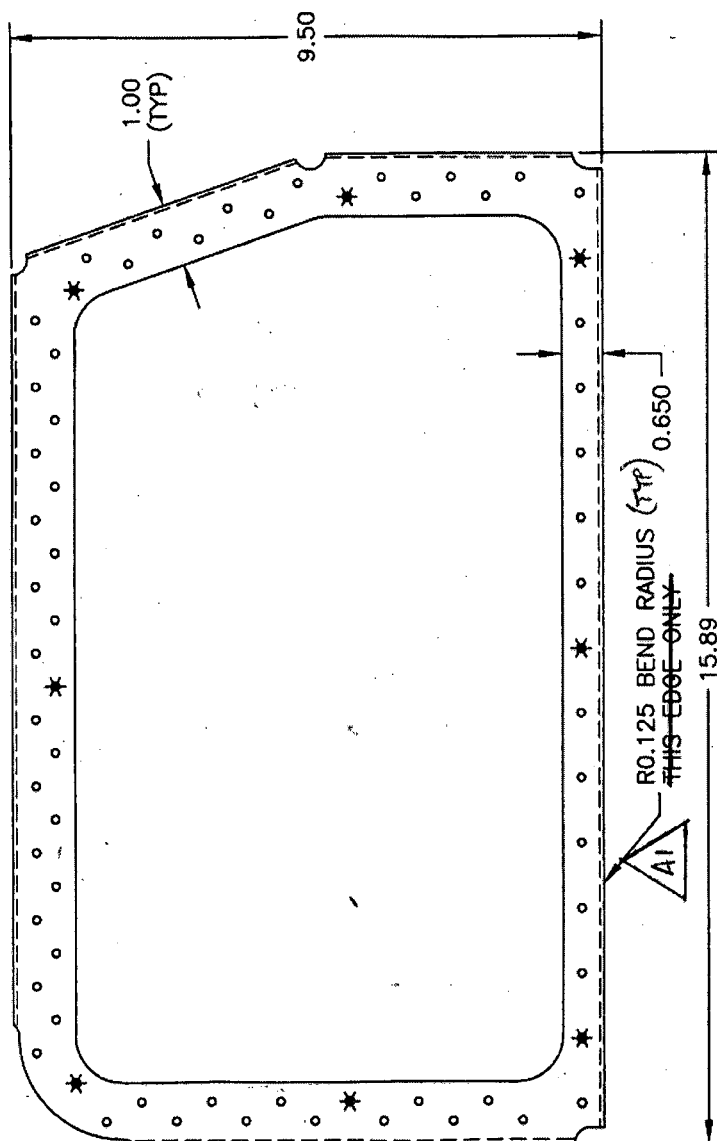
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3211	REV. A SHEET 1 OF 2
DATE 03.09.03		TITLE BRACKET	SCALE 1:3
A	03.09.03	NEW ISSUE	
A1	<i>[Signature]</i> 03.12.05	CHANGE ALL BEND RADII TO R0.125	

RELEASED
03.09.15

D3211-1 BRACKET
MACHINE PER DRAWING FILE "D3211-A2.DWG"
CHECK PER TEMPLATE D3211-1T1
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
FINISH: ACID-ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
USE MINIMUM BEND RADIUS OF 0.125", EXCEPT WHERE INDICATED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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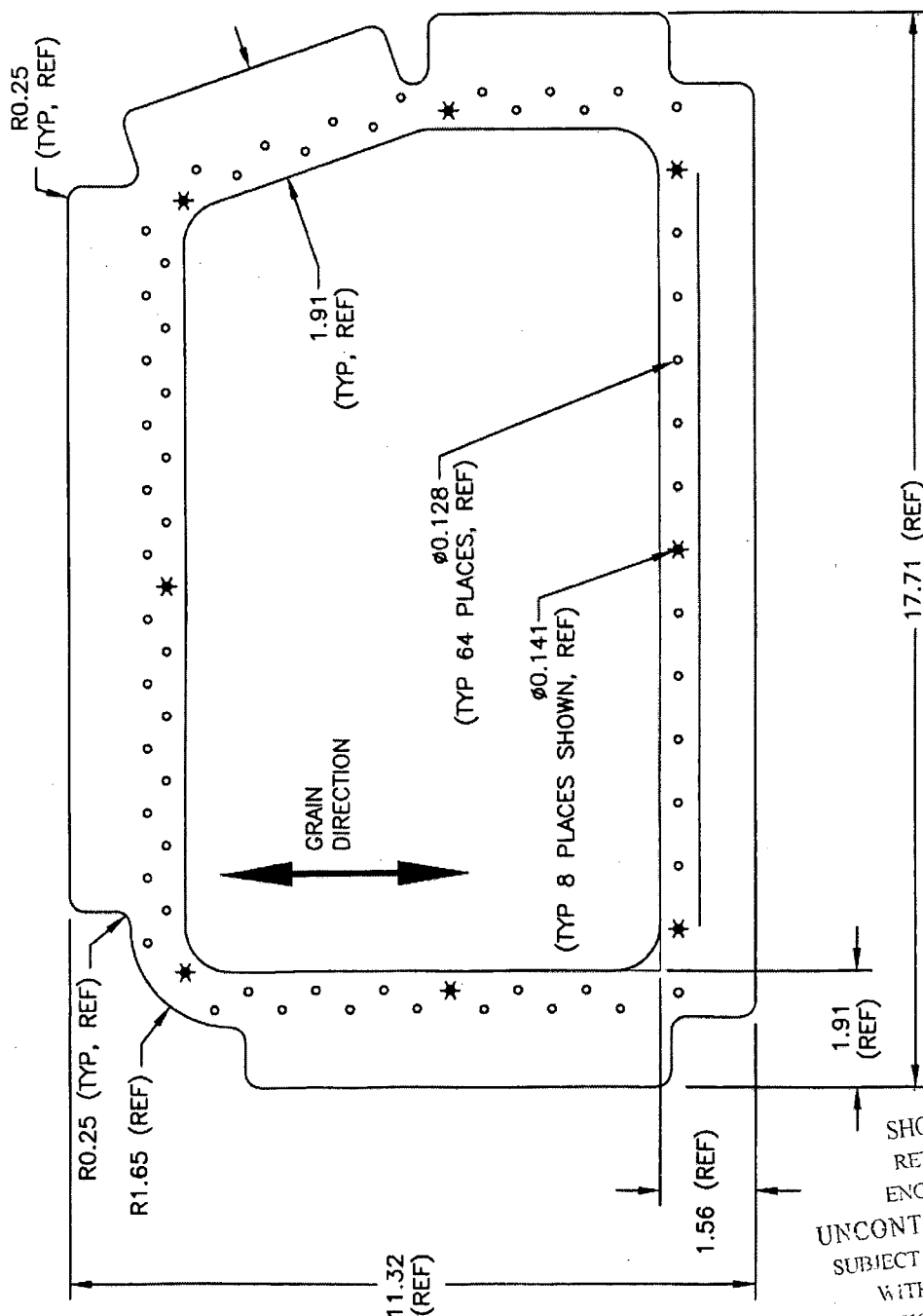
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3211	REV. A SHEET 2 OF 2
DATE 03.09.03		TITLE BRACKET	SCALE 1:3

RELEASED
03.09.15

D3211-1 FLAT PATTERN



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